




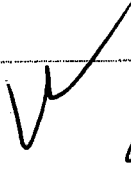



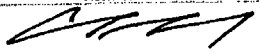


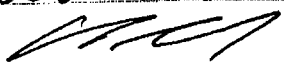


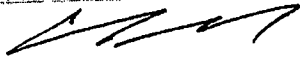


Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : VERTICAL REFERENCE DOOR 212/412	
Job Number : 47327			
Estimate Number : 10887			
P.O. Number :		Part Number : D412711011	
This Issue : 21/04/2009 S.O. No. :		Drawing Number : N/A	
Prsht Rev. : NC		Project Number : N/A	
First Issue : / / Type : PURCHASED PARTS		Drawing Revision : N/A	
Previous Run : 42019		Material :	
Written By :		Due Date : 28/04/2009 Qty: 1 Um: Each	
Checked & Approved By :			
Comment : Est Rev: A 04.09.29 New issue KJ/JLM			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001			
2.0	PG	PURCHASING	
			
Comment: PURCHASING Issue P/O: <u>8599</u> to Eagle Copters  "Assembly of D412-711-011 Door Send a copy of this IPP 			
APR 22 2009			
3.0	D412711041	Vertical Reference Door Assembly	
			
w/645350 APR 22 2009			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy 			
4.0	D41271101	Replacement Bubble Window	
			
08-007858 APR 22 2009			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 			
5.0	D412711111	Wiring Harness, 212/412.	
			
08-002290.5 APR 22 2009			
Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 <u>08-002290.5</u> 			

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412

Instrument Panel, 212/412

%44499

APR 22 2009

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES-ENGINEERING



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 07-011796

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 08-007858

1 EA20469-05 Rubber Strip %44499

1 EA20469-06 Aluminum Strip Om. Head

1 EA20469-07 Angle 44499

1 EA20469-08 Placard 44499

1 EA20469-10 Rear Rib Assy 44499

1 EA20469-11 Angle 44499

1 EA20469-12 Fwd Rib 44499

1 EA20469-13 Window 44499

1 EA20469-14 Window Retainer 44499

1 EA20469-16 Armrest Assy 44499

1 EA20469-17 Angle 44499

1 EA20469-18 Door Inner Skin 44499

1 EA20469-21 Door Cover Panel 44499

2 EA20469-23 Link 44499

1 EA20469-24 Rod 44499

1 EA20469-25 Arm Assy 44499

APR 22 2009

Material Certification / Proof of Traceability / Certificate of Conformity required

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3ABolt	_____
22	AN3-4ABolt	_____
24	AN3-7ABolt	_____
6	AN960-6L Washer	_____
90	AN960-10L Washer	_____
34	CR3242-4-2 Rivet	_____
135	MS20426AD3-3 Rivet	_____
140	MS20426AD4-3 Rivet	_____
25	MS20470AD3-3 Rivet	_____
90	MS20470AD4-3 Rivet	_____
24	MS21042L3 Nut	_____
2	MS21042L06 Nut	_____
13	MS21069L3 Nut Plate	_____
8	MS21069L08 Nut Plate	_____
1	MS21071L3 Nut Plate	_____
1	MS21071L08 Nut Plate	_____
9	MS21075L3 Nut Plate	_____
2	MS24677-12 Screw	_____
6	MS27039-1-09 Screw	_____

APR 22 2009

4/44499

[Handwritten signature]

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



[Handwritten signature]

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

APR 22 2009

9.0

QC5

INSPECT WORK TO CURRENT STEP



[Handwritten signature]

Comment: INSPECT WORK TO CURRENT STEP

APR 22 2009

10.0

PACKAGING 1

PACKAGING RESOURCE #1



[Handwritten signature]

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

APR 22 2009

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
Done 10/04/22

Job Completion



U 9-04-22

Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 45350

V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1

Discrepancy:

Modify Door to Vertical Reference Door

Resolution:

Co-Pilot Door modified as per STC No. SH92-55 on service order 08-003669.

Installed window and assembled door.

1.1 Work Done By: Mike Webber

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81 Signature: Colin Gould on 4/22/2009

Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
BELL212-L	BUBBLE WINDOW ILO EA20469-03 and D412-711-101		LT-08-007858	New	1
204-030-853-037A	SKIN ASSY		LT-08-007702	New	1
20-041-1	BUMPER		LT-08-015922	New	1
20-041-1	BUMPER		LT-08-001400	New	1
MS16624-1062	RETAINER		LT-08-015033	New	1
110-070-41	SEAL		LT-09-005017	New	14
412-110-103	DOOR HANDLE W/LOCK		LT-09-000780	New	1
204-030-499-005	ROLLER ASSY		LT-08-005696	New	1
D412-711-111	LOGGING DOOR HARNESS 212/412		LT-08-002290.5	New	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

Squawk: 1.3

Discrepancy:

Prep parts for paint

Resolution:

Parts prepped for paint

1.3 Work Done By: Colin Gould

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

Squawk: 1.4

Discrepancy:

Refinish door as required

Resolution:

Door painted as required

1.4 Work Done By: Colin Gould


Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

EAGLE COPTERS MAINTENANCE LTD.
 328 METAVIS ROAD N.E. CALGARY ALBERTA T2E 7G9
 DONT APPROVAL No. 6-81

NO. 1000
 Manufacturer SH Type/Model 752/1442
 Part No. 497 030 883 145 Serial No. 7K
 Total time 7/5 Work Order 75350
 I.S.O. 7K Overhaul ☐ NEW ☐
 Inspected ☐ Tested ☐ Repair ☐ Modification ☒ Removal ☐
 Previous Certification 75350
 The maintenance described has been performed in accordance with the applicable standards of airworthiness.
 Apr 23, 2009 
 DATE NAME OF AUTHORIZED INSPECTOR UIC No. / STAMP
 Details of outstanding work and other information on reverse.

EAGLE COPTERS MAINTENANCE LTD.

REMARKS

(Details of work performed/reason for removal)
 Modified Door IAW STC No SH92-55

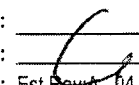
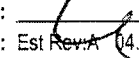
(Additional work to be performed upon installation)

INSTALLED ON _____ DATE _____

EAGLE COPTERS MAINTENANCE LTD.

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR 212/412
Job Number : 47327	
Estimate Number : 10887	
P.O. Number :	Part Number : D412711011
This Issue : 21/04/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 42019	Material :
Written By : 	Due Date : 28/04/2009 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A 04.09.29 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 8599 to Eagle Copters
"Assembly of D412-711-011 Door
Send a copy of this IPP



APR 22 2009

3.0	D412711041	Vertical Reference Door Assembly
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W/45350



APR 22 2009

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Vertical Ref. Door Assy



4.0	D412711101	Replacement Bubble Window
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08-007858



APR 22 2009

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)



5.0	D412711111	Wiring Harness, 212/412
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08-002290.5



APR 22 2009

Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412 08-002290.5



Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412

Instrument Panel, 212/412

W 44499

APR 22 2009

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES-ENGINEERING



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

07-011796

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

08-007858

1 EA20469-05 Rubber Strip

W 44499

1 EA20469-06 Aluminum Strip

Omitted

1 EA20469-07 Angle

44499

1 EA20469-08 Placard

44499

1 EA20469-10 Rear Rib Assy

44499

1 EA20469-11 Angle

44499

1 EA20469-12 Fwd Rib

44499

1 EA20469-13 Window

44499

1 EA20469-14 Window Retainer

44499

1 EA20469-16 Armrest Assy

44499

1 EA20469-17 Angle

44499

1 EA20469-18 Door Inner Skin

44499

1 EA20469-21 Door Cover Panel

44499

2 EA20469-23 Link

44499

1 EA20469-24 Rod

44499

1 EA20469-25 Arm Assy

44499

Material Certification / Proof of Traceability / Certificate of Conformity required

APR 22 2009

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt _____

22 AN3-4ABolt _____

24 AN3-7ABolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

APR 22 2009

4/44499

[Signature]

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



[Signature]

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

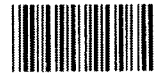
Send this W/O back to DartKit to be stocked at Eagle

APR 22 2009

9.0

QC5

INSPECT WORK TO CURRENT STEP



[Signature]

Comment: INSPECT WORK TO CURRENT STEP

APR 22 2009

10.0

PACKAGING 1

PACKAGING RESOURCE #1



[Signature]

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

APR 22 2009

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date: Tuesday, 21/04/2009 10:49:43 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR 212/412
Job Number :	47327		
Estimate Number :	10887		
P.O. Number :		Part Number :	D412711011
This Issue :	21/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	/ /	Project Number :	N/A
Previous Run :	42019	Drawing Revision :	N/A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	28/04/2009
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	Est Rev: A 04.09.29 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 8599 to Eagle Copters

"Assembly of D412-711-011 Door

Send a copy of this IPP

u 59.04.21

3.0	D412711041	Vertical Reference Door Assembly
-----	------------	----------------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0	D412711101	Replacement Bubble Window
-----	------------	---------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0	D412711111	Wiring Harness, 212/412
-----	------------	-------------------------

**Comment:** Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D412-711-111 Wiring Harness, 212/412

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES-ENGINEERING



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

1 EA20469-05 Rubber Strip

1 EA20469-06 Aluminum Strip

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

1 EA20469-12 Fwd Rib

1 EA20469-13 Window

1 EA20469-14 Window Retainer

1 EA20469-16 Armrest Assy

1 EA20469-17 Angle

1 EA20469-18 Door Inner Skin

1 EA20469-21 Door Cover Panel

2 EA20469-23 Link

1 EA20469-24 Rod

1 EA20469-25 Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt _____

22 AN3-4ABolt _____

24 AN3-7ABolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Tuesday, 21/04/2009 10:49:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 47327

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

